

5/43

586

DART AEROSPACE LTD	Work Order:	24519
Description: Wearplate	Part Number:	D3460-1
Dwg: D3460 Rev. A; D2577 Rev. E	Qty:	8
		Page 1 of 1

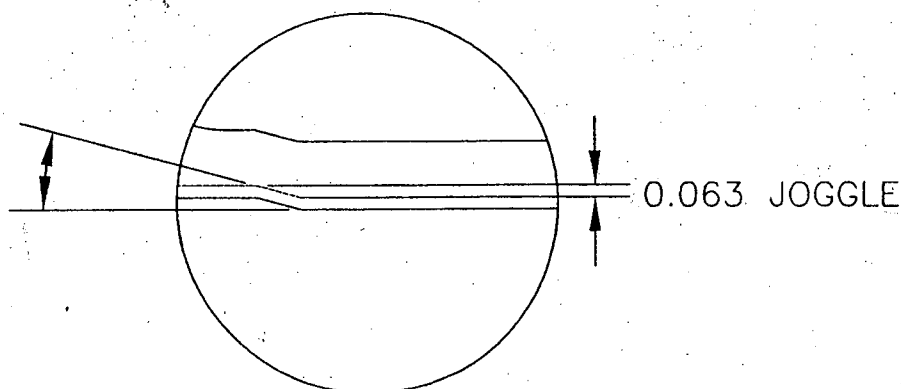
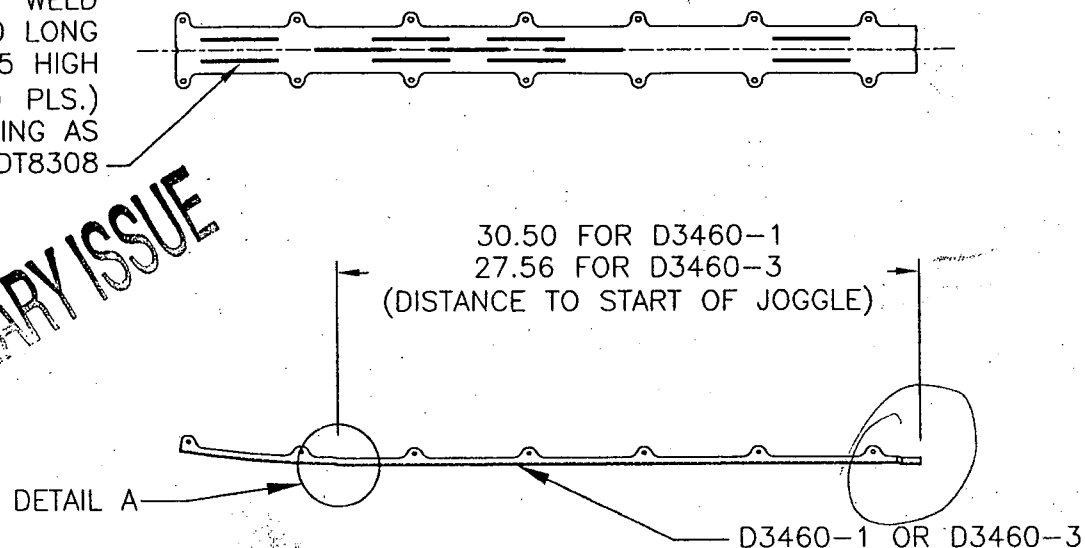
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	HA	05.10.20	8
2	PG	Issue P/O: 2008744 Email or Ship DXF file to vendor Laser Cut D2577-101 flat pattern as per Dwg D2577 Material release note required	LA	05.10.30	8
3	RG	Receive and Inspect for transit damage Ensure that material release note is attached	CL	05/10/12	8
4	QC6	Inspect dimensions per template D2577-101T	SB	05/10/20	8
5	GB	Deburr if necessary		N/A	
6	GB	Form on brake as per Dwg D2577 using DT8155 and DT8179	SB	05/10/20	8
7	GB	Form end joggle as per Dwg D2577 using DT8157 Identify as D3460-1	SB	05/10/20	8
8	GB	Form Detail "A" joggle of Dwg D3460 using DT8157	SB	05/10/20	8
9	QC5	Inspect work to Step 8	J	05.10.25	8
10	WS	Weld hard surface using DT8308A & DT8308B as per Dwg D3460 Qty Part Number Description Batch A/R 7560 Hardcoat Rod M17953 M18952	CPL	05.11.16	4
11	QC9	Inspect weld	DA	05/11/23	4
12	FP	Powder Coat Grey Sandtex (Ref.4.3.5.6) per QSI 005 4.3	M	05.11.24	4
13	QC3	Inspect Powder Coat	CL	05/11/25	4
14	ST	Identify and Stock	M	05.11.25	4
15	AC	Cost / part:	SAC	05.11.28	4
16	DC	Close W/O Inspect Level 21	QD	05/11/28	4

Rev	Date	Change	Revised By	Approved
A	05.10.20	New Issue	KJ/EC	E

PRELIMINARY ISSUE

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

PRELIMINARY ISSUE



5. SHOP COPY
RETURN TO
ENGINEERING
OFFICE
COPY
NO. 24519
WORK ORDER

D3460-1/-3 WEARSHOE

- 1) MAKE D3460-1 FROM D2577-11 LONGITUDINAL BEND
- 2) MAKE D3460-3 FROM D2577-13 LONGITUDINAL BEND
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.10.04	DRAWING NO.	D3460	REV. A
		TITLE	WEARSHOE	SHEET 1 OF 1
A		05.10.04	NEW ISSUE	SCALE 1:10